Work Order ID 52356

Tuesday, September 22, 2009 12:27:08 PM

Item ID: D3290-3 **Accept**

Revision ID: C

Item Name: Window

Setup Start / Stop

Start Date: 9/23/2009 **Start Qty:** 4.00 **Cust Item ID:**

Required Date: 10/9/2009 **Req'd Qty:** 4.00 **Customer:**

Reference:

Run Start / Stop

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D3290	Rev C

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100 Waterjet FLOW CNC Waterjet	FLOW WATER JET **Memo** 1-Cut as per Dwg D3290 ☐Dwg Rev: C ☐Prog Rev: C ☐2-Deburr if necessary	0.00 0.00					IB	9-10	15
110 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00					IB	9-10	15
120 QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00							

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Start Date: 9/23/2009 **Start Qty:** 4.00
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Reference:

Cust Item ID:
Customer:

Run **Start**
Stop

Approvals: **Process Plan:** ______________ **Date:** __________ **Tooling:** ____________ **Date:** __________
QC: ____________________ **Date:** __________ **SPC (Y/N):** __________ **Date:** __________

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Thermoform Thermoforming Machine	HAND FINISHING THERMOFORMING **Memo** Without removing protective skin□remove sharp edge by degurring.	0.00 0.00				____	____	____	BB 09/10/19 X9
140 Thermoform Thermoforming Machine	THERMOFORMING MACHINE **Memo** 1-THERMOFORM as per Drawing D3290 and Folio FTA001□ Dwg. Rev.___C___ □ Folio Rev__________□2-Engrave part# & batch#, □(D3290-3)	0.00 0.00				____	____	____	BB 09/10/19 X9
150 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00				____	____	____	BB 09/10/19 X9

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Reference:

Run **Start** **Stop**

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC8- Inspect parts - second check	0.00							WL 09/10/19 (X9)
	Memo	0.00							
170 Thermoform Thermoforming Machine	HAND FINISHING THERMOFORMING	0.00				9	Ø		BD 09/10/19 (X9)
	Memo Water sand and buff to remove scractches if required	0.00							
180 QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00				(X5)	Ø		
	Memo	0.00 2) S 09/10/19							

Work Order ID 52356

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Start Date: 9/23/2009 **Start Qty:** 4.00
Required Date: 10/9/2009 **Req'd Qty:** 4.00
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________
QC: ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Run **Start** / **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours		Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 Packaging Packaging	Identify as per dwg & Stock Location:______ ⇒ window used in w/o 52965 Memo	0.00 0.00	SAD	09-10-30			9			[signature]
200 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						09/11/02		[signature] MF 09-10-30

Picklist Print

Tuesday, September 22, 2009 12:27:08 PM

Work Order ID: 52356

Parent Item: D3290-3RevC

Parent Item Name: Window

Start Date: 9/23/2009 **Required Date:** 10/9/2009

Comments:

Start Qty: 4.00 **Required Qty:** 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MACRLICS.125 1/8" Polycast II Sheet		Purchased	No			100	sf	129.8668	12.6316	32.00	18 9-10-15	

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
MAT	129.8668		
110115	4		
110633	58.1221		
111711	67.7447		
112888			112888

DART AEROSPACE LTD	Work Order:	52358
Description: Window	Part Number:	D3290-3
Inspection Dwg: D3290 **Rev:** C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.58	+/-0.030	26.58	✓			
16.08	+/-0.030	16.08	✓			
13.79	+/-0.030	13.79	✓			
12.40	+/-0.030	12.40	✓			
8.81	+/-0.030	8.81	✓			

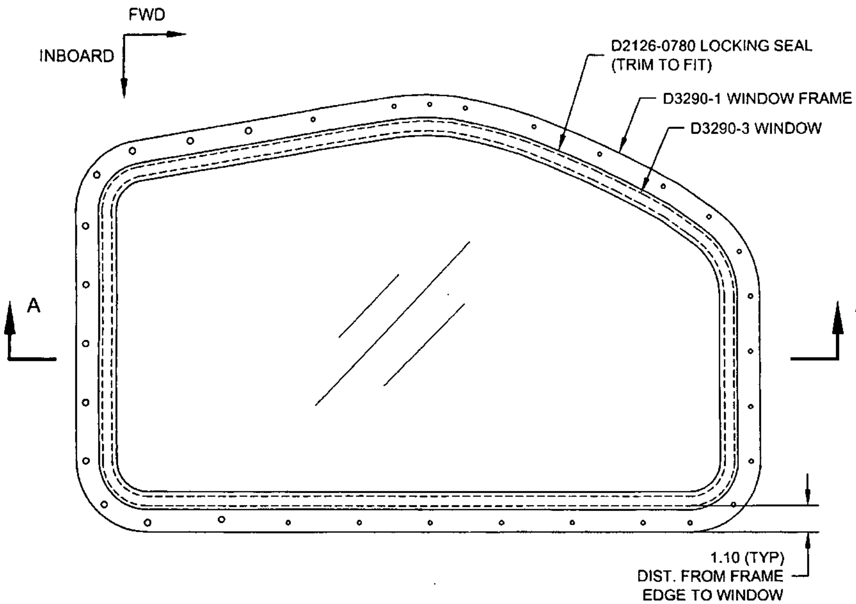
Measured by:	[initials]
Date:	9-10-15

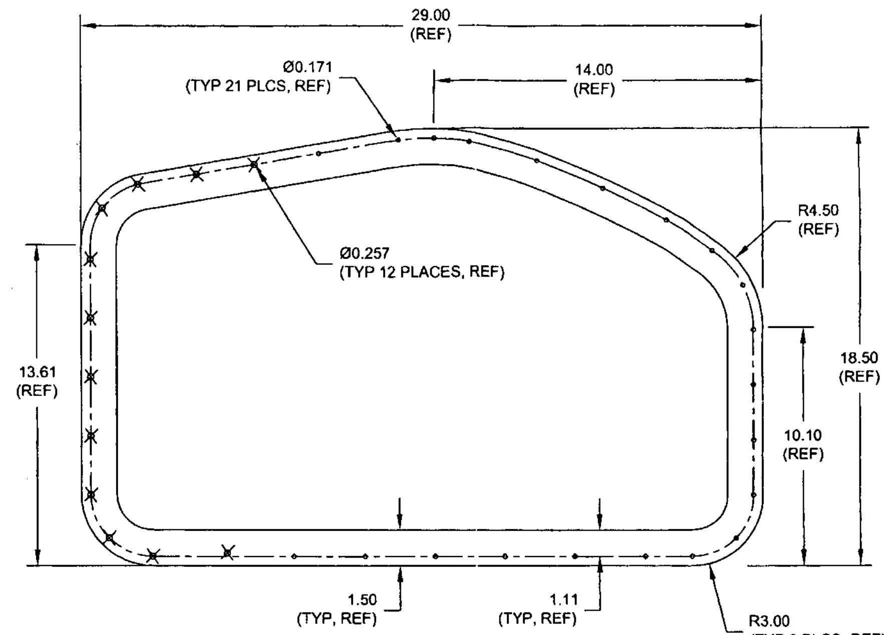
Audited by:	[initials]
Date:	07/10/15

Prototype Approval:	N/A
Date:	N/A

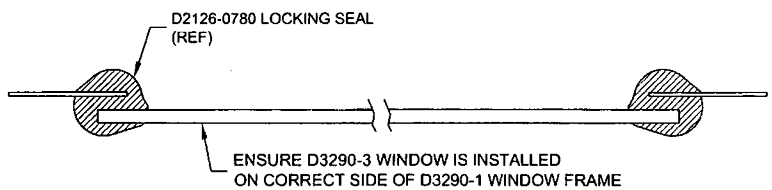
Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DD [initials]	[initials]

W/O 52356





D3290-1 FRAME



SECTION A-A
NTS

D3290-1 NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.040)
OR
5052-H32 ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/8 OR AMS 4016
(REF. DART SPEC. M5052H32S.040)
2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3
3) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
4) IDENTIFICATION: IDENTIFY WITH DART P/N "D3290-1" USING FINE POINT PERMANENT INK MARKER
5) WEIGHT: 0.47 LBS

RELEASED 07.09.22

DEO ATTACHED

D3290-041 REPLACEMENT WINDOW ASSEMBLY

D3290-041 NOTES:
1) WEIGHT: 3.66 LBS

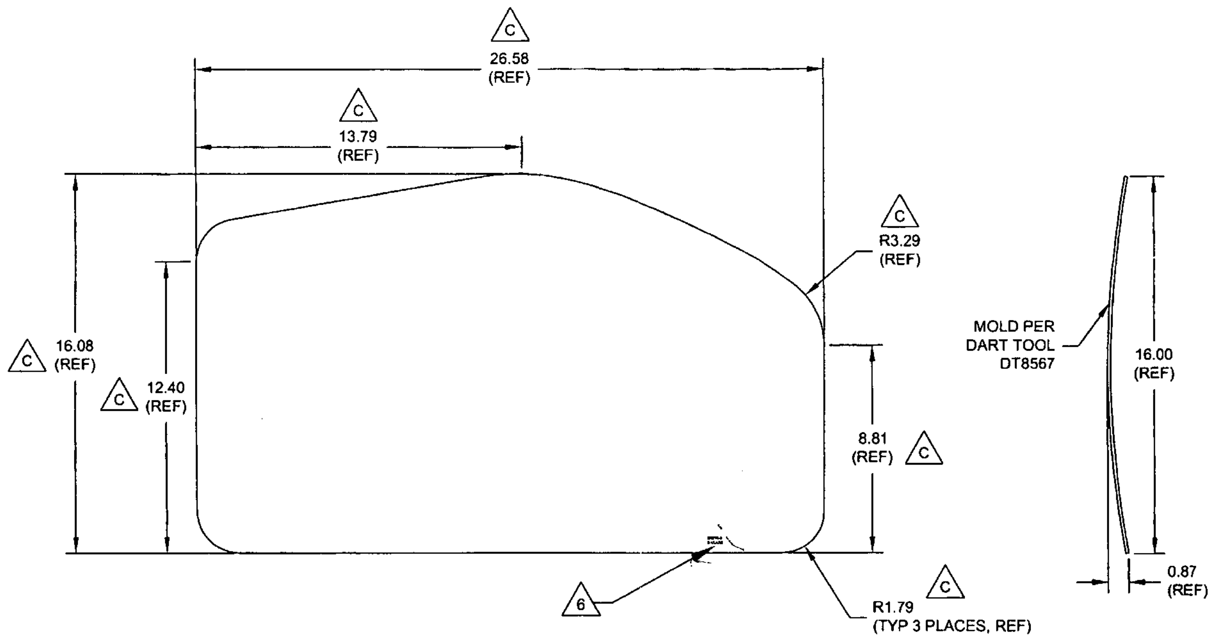
GENERAL NOTES:
1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
2) UNITS: INCHES UNLESS OTHERWISE NOTED

UNDER REVIEW
09.09.18
PAR 09-033

REV.	DESCRIPTION	BY	DATE
C	UPDATE DIMS PER PAR 188	DC	07.07.24
B	UPDATE MATERIAL PER NCR 029	MB	06.04.20
A	NEW ISSUE	RF	04.06.14

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	DC	
CHECKED		DRAWING NO. REV. C
MFG. APPR.		D3290 SHEET 1 OF 2
APPROVED		TITLE SCALE
DE APPR.		REPLACEMENT WINDOW ASSEMBLY 1:5
DATE	07.07.24	

W/O 52356



D3290-3 WINDOW

UNDER REVIEW 05.09.18

DEO ATTACHED

RELEASED 07.09.22

D3290-3 NOTES: (B)

1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425
OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER
LP-391 TYPE 1 GRADE C, 0.125 THICK
(REF. DART SPEC. M-ACRYLIC-S.125)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) REMOVE SHARP EDGES
6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
7) WEIGHT: 1.87 +/- 0.42 LBS
8) MOLD PER DART TOOL DT8567

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. C
CHECKED		D3290	SHEET 2 OF 2
MFG. APPR.		TITLE	SCALE
APPROVED		REPLACEMENT WINDOW ASSEMBLY	1:5
DE APPR.			
DATE	07.07.24		

DRAWING NO. D3290	TITLE REPLACEMENT WINDOW ASSEMBLY REV. C	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3290-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN	CHECKED	MFG. APPR.	APPROVED	DE APPR.	
DATE 09.09.18	DATE 09.09.18	DATE 09.09.18	DATE 09/09/21	DATE 09/09/21	

w/o 52356

PURPOSE:
CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR 09-033.

CHANGE:
MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

D3290-1 NOTES

1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
~~(REF. DART SPEC. M6061T6S.040)~~ REF. DART SPEC. M6061T6S.063 (REPLACE)
OR
5052-H32 ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
PER AMS-QQ-A-250/8 OR AMS 4016
~~(REF. DART SPEC. M5052H32S.040)~~ REF. DART SPEC. M5052H32S.063 (REPLACE)

RELEASED
2009-10-09